

dup Jim S

Work Order ID 77709

77709

Page 1

December-19-11 8:20:51 AM

Item ID: D206-642-241

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Replacement Skidtube

Start Date: 19/12/2011 Start Qty: 1.00

1

Cust Item ID:

Required Date: 02/01/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: M.L.J

Date: 11/12/19 Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2650

Rev F

100

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy, bluefile & type labels per PPP D206-642-241

CHG005

Sic 12/01/04

OK for MLJ 12/01/04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

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Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

110

0.00

110

Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-Deburr Fwd edge of tube

2- Remove ridge on inside of Fwd edge of tube as per Dwg D2650

3-Weld Fwd Cap as per Dwg D2650, Use aluminum rod. Grind D2647 to fit as required.

Pick:

Qty Part Number Description Batch

A/R Aluminum Rod

M117889

4-Grind weld flush to cap on top surface only.

5-Cut Aft end as per dwg 2650 from front of tube and Deburr

6-Remove inner indexing ridge on Aft end of skidtube as per Dwg D2650.

7-Open holes for Aft end cap as per Dwg D2650 with #30 Drill Bit using DT8025.

8-Drill pilot holes using Dt 8167.

9-Locate DT8732 from inner Aft saddle hole & 3rd crossbolt hole. Insert D3286-1 doubler using DT8732 & D206-642-241-T1, then locating doubler off of 3/16" holes, cleco DT8732 & doubler leaving DT8732 for added support.

10- Drill D3286-1 doubler rivet holes in tube using # 30 drill spot drilling doubler at the same time.

/ 0 8E11-12-28

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Date: _____

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Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

11-Working from the center out, drill # 30 holes into D3286-1 doubler. Cleco each hole as it is being drilled. Verify angle of holes to accommodate rivet heads.

12-Remove 3/16" cleco's only and open GHW holes to Ø0.500" as per Dwg D2650

13-Remove D3286-1 doublers, identify orientation, deburr, then attach them to the workorder

14-Remove indexing edge using DT8741 as per Dwg D2650

15-C'sink GHW rivet holes as per Dwg D2650

120

QC6- Inspect dimensions to drawing

0.00

120

QC

Memo

0.00

Quality Control

8 4/17/28

BE11-12-28

Dart Aerospace Ltd

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NR1

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Process Plan:

Date:

Tooling:

Date:

Stop

NR2

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Skidtubes	0.00							
130									
Skidtubes	Memo	0.00							
Skidtubes	1-Open crossbolt holes to Ø0.3125"								
	2-Drill pilot holes using DT8028-3, then open to Ø0.297" as per Dwg D2650. Open Aft cap hole #6.								
	3-Deburr tube and blow out chips from inside the tube								
140	Chemical Conversion Coat per QSI005 4.1	0.00							
140									
HandFinish	Memo	0.00							
Hand Finishing									
150	QC3- Inspect Part Finish	0.00							
150									
QC	Memo	0.00							
Quality Control									

130 11/12/29

SAD 11-12-29

1 8 BE11-12-29

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Run Start ***NR1***

QC: Date: SPC (Y/N): Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160

0.00

160

Skidtubes

0.00

Skidtubes

Memo

1-Open holes to finished size as per Dwg D2650, D2650-3 Drilling Detail
(without cutting fluid)

2-C'sink crossbolt spacer holes as per Dwg D2650(without cutting fluid)

3-Deburr and blow out all chips from inside the tube

170

QC6- Inspect dimensions to drawing

0.00

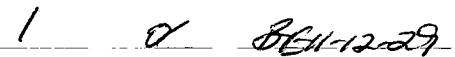
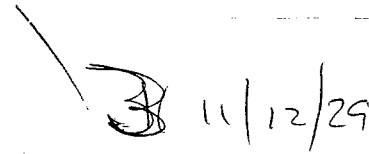
170

QC

Memo

0.00

Quality Control



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Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start ***NR1***

QC: Date: SPC (Y/N): Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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180

0.00

180

Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-Locate, install and rivet doublers as per Dwg D2650. Micro-shave rivets as required

> SAD

①

11-12-29

2-Bond D2654-3 web in place as per QSI 015. Ensure holes line up. Allow 12 Hrs. cure time before cutting

> CF

①

~~11-12-29~~

Start Date: 11-12-29 Time: 4:00

Finish Date: 12-01-02 Time: 7:00

Pick:

Qty Part Number Description Batch

A/RSikaflex-291 M119508
Sikaflex expire date: 2012/08/13

190

QC5- Inspect part completeness to step on W/O

0.00

190

QC

Memo

0.00

Quality Control

12-01-02
1 0 BE-11-12

W/O:		WORK ORDER CHANGES					
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Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start *NR1*

QC: Date: SPC (Y/N): Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

200

0.00

200

Skidtubes

0.00

Skidtubes

Memo

1-remove alodine from around hole and prepare for welding

2-Prep per QSI 005 and Insert D2649 crossbolt spacers. Weld as per QSI 004 and Dwg D2650. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod.

Pick:

QtyPart NumberDescriptionBatch
A/RAluminum Rod M117889

3-Grind welds flush as per Dwg D2650.

4-Using DT8733, insert (2) D3286-3 spacers as per QSI 004 and Dwg D2650. Remember to back drill each hole to Ø0.402" before welding other side. Use SS rod as required.

A/RSS Rod NONE BE-12-01-02

5-Counterbore 5/16" x 0.750" deep except 7th hole from Aft end as per Dwg D2650. Deburr

3 BE 12-01-02

JB 12/01/02

NP 12-1-3

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Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210	HandFinishing	0.00							
210	HandFinish	0.00							
Hand Finishing	Memo Install D2680-041 Nut Plate as per Dwg D2650	0.00							
215	QC	0.00							
220	QC10- Inspect visual per QS1004- ground welds	0.00							
220	QC	0.00							
Quality Control	Memo	0.00							
230	QC5- Inspect part completeness to step on W/O	0.00							
230	QC	0.00							
Quality Control	Memo	0.00							

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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NS1

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Required Date: 02/01/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Run Start

NR1

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

NR2

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

240

Pressure Wash per QSI005 4.3

0.00

240

HandFinish

Memo

0.00

Hand Finishing

Brush alodine tube on crossbolt spacer area, do not acid etch, do not dip tube in tank.

1X ~~φ~~ M-L 12/01/03

250

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

250

Powdercoat

Memo

0.00

Powder Coating

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

2:40
320°F
3:10

1X ~~φ~~ M-L 12/01/03

260

QC3- Inspect Part Finish

0.00

260

QC

Memo

0.00

Quality Control

1RH ~~φ~~ M-L 12/01/03

M119480

Dart Aerospace Ltd

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Date:

Stop

NR2

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

270

270

HandFinish

Hand Finishing

HandFinishing

Memo

0.00

1- Install inserts & wearpads as per dwg D2922. Use a drop of Sikaflex inside insert holes before installing wearpad/wearplate.

✓ A/RSikaflex-291 11/11/08
Sikaflex expire date: 12/09

✓ 2-Install D2651-3 O-Rings on D2651-1 plugs with Petroleum Jelly and install plugs as per Dwg D2650 (D2650-3 detail). Clean excess adhesive.

✓ 3-Install MS27039-4-06 Screw as per DEO 9153.

4 -Install D2646 Aft Cap and seal with Sikaflex. Clean excess adhesive

✓ A/RSikaflex-291 11/11/08
Sikaflex expire date: 12/09

5 -Wing Walk as per Dwg D2650-3 and QSI 005 4.4

✓ A/R Batch: 11/11/09
Batch: 11/11/09

300

300

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

1 0 11 12/01/09

8 12/01/09

Dart Aerospace Ltd

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Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
310	Packaging	0.00							
310									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D206-664-241								
	Location: _____								
	PPP Rev: <u>A</u>								
320	QC21- Final Inspection - Work Order Release	0.00							
320									
QC	Memo	0.00							
Quality Control									

12/1/11

12/01/05

ME

12-01-04

W/O:		WORK ORDER CHANGES					
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Picklist Print

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Parent Item: D206-642-241

D206-642-241

Parent Item Name: Replacement Skidtube

Start Date: 19/12/2011

Required Date: 02/01/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev: 04.12.02 Revised procedural steps KJ/JLM IPP RevP: revise and update route/bom DD 10.01.06 verified by: ECIPP rev Q 10.02.19 per PAR 09-043 EC verified by: DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2620

Manufactured

No

110

Each

24.0000

1

1

D2620

Skidtube, 206 Skidtube

**

BE11-12-23

Location

Loc Qty

Loc Code

LG

24

71616

3

71617

6

75470

2

75471

1

75587

10

76816

2

D3286-1

Manufactured

No

110

Each

204.0000

2

2

D3286-1

Doubler

**

BE11-12-28

Location

Loc Qty

Loc Code

LG002

204

74872

6

75484

80

D2647

Manufactured

No

110

Each

184.0000

1

1

D2647

Cap

**

BE11-12-23

Location

Loc Qty

Loc Code

LG002

184

73826

75

75482

109

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D206-642-241

Parent Item Name: Replacement Skidtube

Start Date: 19/12/2011

Required Date: 02/01/2012

Start Qty: 1.00

Required Qty: 1.00

D2654-3 Manufactured No

180 Each

1.0000 1 1

D2654-3

Web

**

Location

Loc Qty

Loc Code

LG

1

~~77075~~

1

CR3212-4-04

Purchased No

180

Each

13,132.00 52

CR3212-4-04

Cherry Rivet

**

52

11-12-29

Location

Loc Qty

Loc Code

ST331

3142

116471

78

117816

3

118686

1

118840

16

119017

3034

119075

10

st510

9990

119075

9990

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

December-19-11 8:20:58 AM

Page 3

Work Order ID: 77709

77709

Parent Item: D206-642-241

D206-642-241

Parent Item Name: Replacement Skidtube

Start Date: 19/12/2011

Required Date: 02/01/2012

Start Qty: 1.00

Required Qty: 1.00

D2649 Manufactured No 200 Each 786.0000 18 18

D2649

Cross Bolt Spacer

**

BE 12-01-02

Location	Loc Qty	Loc Code
LG001	786	
65317	1	
68224	2	
68507	11	
71355	2	
72704	2	
72841	11	
73390	8	
73857	21	
73858	53	
73859	4	
73860	4	
76793	667	

18

D3286-3 Manufactured No 200 Each 46.0000 2 2

D3286-3

Spacer

**

BE 12-01-02

Location	Loc Qty	Loc Code
LG001	1	
74117	1	
LG002	45	
75483	45	

2

D2680-041 Manufactured No 210 Each 81.0000 1 1

D2680-041

Nut Plate

**

(1)

BE 12/01/02

Location	Loc Qty	Loc Code
ST020	81	
75479	81	

December-19-11 8:20:58 AM

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Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 4

Work Order ID: 77709

77709

Parent Item: D206-642-241

D206-642-241

Parent Item Name: Replacement Skidtube

Start Date: 19/12/2011

Required Date: 02/01/2012

Start Qty: 1.00

Required Qty: 1.00

CR3212-4-03

Purchased

No

210

Each

1,800.000

2

2

CR3212-4-03

Cherry Rivet

**

2 12/01/02

Location

Loc Qty

Loc Code

FP002

806

114859

806

ST331

994

110139

2

119017

992

CCR264SS3-3

Purchased

No

210

Each

1,027.000

2

2

CCR264SS3-3

Cherry Rivet

**

2 12/01/02

Location

Loc Qty

Loc Code

ST331

1027

113973

2

117849

147

119017

878

D2646

Manufactured

No

270

Each

166.0000

1

1

D2646

Aft Cap

**

11 12/01/04

Location

Loc Qty

Loc Code

FP002

166

62678

5

68280

5

70945

1

71038

4

71070

2

73294

1

73825

148

yi

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 5

Work Order ID: 77709

77709

Parent Item: D206-642-241

D206-642-241

Parent Item Name: Replacement Skidtube

Start Date: 19/12/2011

Required Date: 02/01/2012

Start Qty: 1.00

Required Qty: 1.00

D2651-1

Manufactured No

270 Each

417.0000 18 18

D2651-1

Plug

**

12/01/04

Location

Loc Qty

Loc Code

FP001

417

57869

1

66445

10

69018

2

70839

2

71037

31

73827

371

x18

AN960JD416

NAS1149D0463J

Purchased

No

270 Each

0.0000 1 1

AN960.ID416

Washer

**

M118384(x1) 12/01/04

D2651-3

Manufactured No

270 Each

907.0000 18 18

D2651-3

O-Ring

**

12/01/04

Location

Loc Qty

Loc Code

FP001

907

61962

12

73828

895

x18

MS27039-1-08

Purchased

No

270 Each

1,321.000 46 46

MS27039-1-08

Screw

**

12/01/04

Location

Loc Qty

Loc Code

ST291

1321

117423

77

118910

246

119075

498

119109

500

1/216

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 6

Work Order ID: 77709

77709

Parent Item: D206-642-241

D206-642-241

Parent Item Name: Replacement Skidtube

Start Date: 19/12/2011

Required Date: 02/01/2012

Start Qty: 1.00

Required Qty: 1.00

ALS4-1032-130

Purchased

No

270

Each

2,158.000

44

44

AI S4-1032-130

Insert

**

12/01/04

Location

Loc Qty

Loc Code

ST280

1968

119084

1968

xc14

ST281

190

119632

190

MS27039-4-06

Purchased

No

270

Each

333.0000

1

1

MS27039-4-06

Screw

**

12/01/04

Location

Loc Qty

Loc Code

ST292

333

119075

333

xl

AN960JD10L

NAS1149D0332J

Purchased

No

270

Each

0.0000

46

46

*AN960JD10L *

Washer

**

11/03/04 (x46) 12/01/04

D3537-1

Manufactured

No

270

Each

68.0000

4

4

D3537-1

Wearpad

**

(x4) 12/01/04

Location

Loc Qty

Loc Code

FP002

68

B77036

x3

69817

5

74867

63

xl

D3537-3

Manufactured

No

270

Each

3.0000

1

1

D3537-3

Wearpad

**

B76986 (x1) 12/01/04

Location

Loc Qty

Loc Code

FP002

3

73305

3

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Page 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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77709

D206-642-241

Required Date: 02/01/2012

Required Qty: 1.00

... 12/01/04 ...

XI

11 12 13 14

VI

Jul 120104

$$\frac{y}{1}$$

18/01/04

✓

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

December-19-11 8:20:58 AM

Page 8

Work Order ID: 77709

77709

Parent Item: D206-642-241

D206-642-241

Parent Item Name: Replacement Skidtube

Start Date: 19/12/2011

Required Date: 02/01/2012

Start Qty: 1.00

Required Qty: 1.00

D3535-33

Manufactured No

270 Each

15.0000

1 1

D3535-33

Wearshoe

**

3U 12/01/04

Location

Loc Qty

Loc Code

FP001

15

70383

5

70462

10

VI

D3536-33

Manufactured No

270 Each

23.0000

1 1

D3536-33

Gasket

**

3U 12/01/04

Location

Loc Qty

Loc Code

FP002

23

70382

7

70465

16

KI

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

QTY -1	QTY -3	QTY -5	QTY -7	PART NUMBER	DESCRIPTION
X				D2650-1	SKIDTUBE ASSEMBLY
	X			D2650-3	SKIDTUBE ASSEMBLY
		X		D2650-5	SKIDTUBE ASSEMBLY
			X	D2650-7	SKIDTUBE ASSEMBLY
1	1	1	1	D2600-1-160	EXTRUSION
1				D2654-1	WEB
	1			D2654-3	WEB
		1		D2654-5	WEB
			1	D2654-7	WEB
1	1	1	1	D2646	AFT CAP
1	1	1	1	D2647	CAP
17	18	19	23	D2649	CROSS BOLT SPACER
16	18	14	22	D2651-1	PLUG
16	18	14	22	D2651-3	O-RING
1	1	1	1	D2680-041	NUT PLATE
2	2			D3286-1	DOUBLER
2	2			D3286-3	STUD
42	44	54	60	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, ALS7-1032-130)
2	2	2	2	AN960JD10L	WASHER
2	2	2	2	CCR264SS3-3	RIVET
2	2	2	2	CR3212-4-03	RIVET
2	2	2	2	MS27039-1-08	SCREW
1	1	1	1	MS27039-4-06	SCREW
1	1	1	1	AN960JD416	WASHER
52	52			CR3212-4-04	RIVET

F

F

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
-POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
-BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) WELD PER DART QSI 004
- 9) DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- 10) BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015
- 11) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)
- 12) DRILL Ø0.297 FOR ALS7-1032-130 INSERTS USING TEMPLATE DT8056-1 ON -1 TUBE, DT8056-3 ON -3 TUBE, DT8056-5 ON -5 TUBE, AND DT8056-7 ON -7 TUBE. INSTALL INSERTS AFTER FINISH.
- 13) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOWN BY
REVISION
FOR THE
UNCONTROLLED COPY
SUBMIT TO THE
WE CAN
NO 77709 M.C.J
11/12/19

RELEASED
08-23-19

F	DRAWING UPDATED TO CURRENT STANDARDS. SHT 6 ADDED. ALL SECTION AND DETAIL VIEWS TRANSFERRED TO SHT 6. SHT 1 IN PL PART D2649 QTY UPDATED. SHT 6 SECT C-C GRIND INSTRUCTIONS DELETED FROM NOTE 7 (SEE NCR 239).	AJS	08.08.08
E	REMOVE CBORE, CHG DRILL, ADD CHAMFER	CP	06.03.30
D	REDRAW: INCCORP. DEO9136/9153/9163 MOD GROUND HANDLING ON D2650-1/-3	CP	04.05.17
C	CHANGE HOLE PATTERN AND FRONT END	DS	97.10.29
B	AS MANUFACTURED CHANGES	DS	97.06.26
A	NEW ISSUE	DS	97.03.25
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 1 OF 6
APPROVED		TITLE	SCALE
DE APPR.		206/407 SKIDTUBE ASSEMBLIES	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

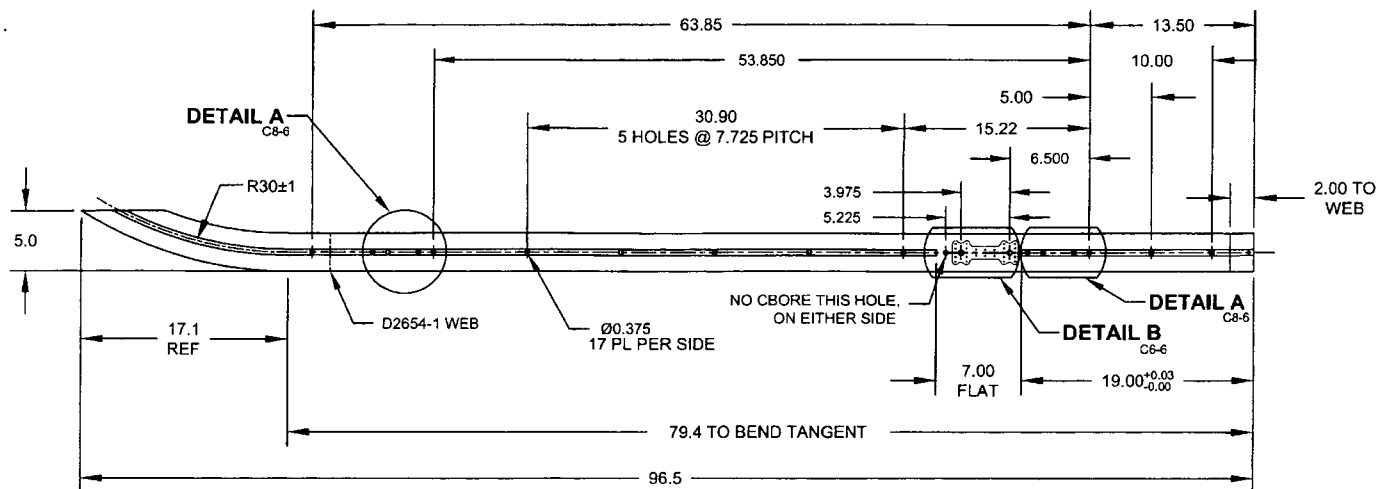
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

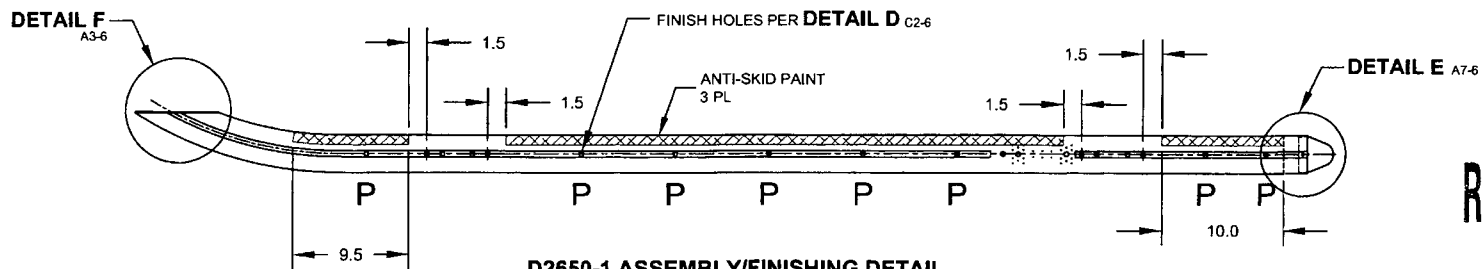
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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D2650-1 BENDING/DRILLING DETAIL



D2650-1 ASSEMBLY/FINISHING DETAIL

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MFG. APPR.		D2650	SHEET 2 OF 6
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

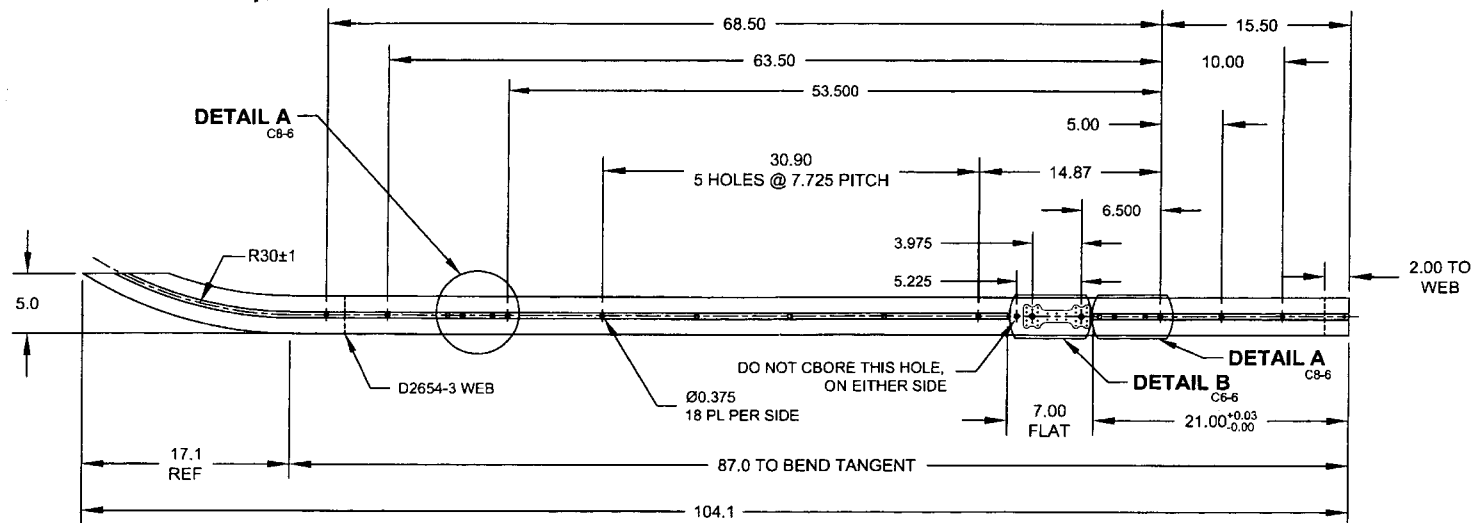
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

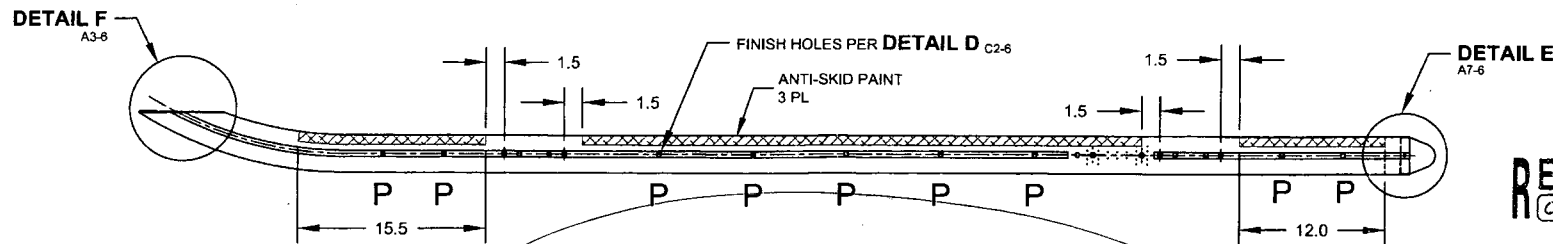
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

77709







D2650-3 BENDING/DRILLING DETAIL



D2650-3 ASSEMBLY/FINISHING DETAIL

RELEASED
05 07 22 1118

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DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 3 OF 6
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

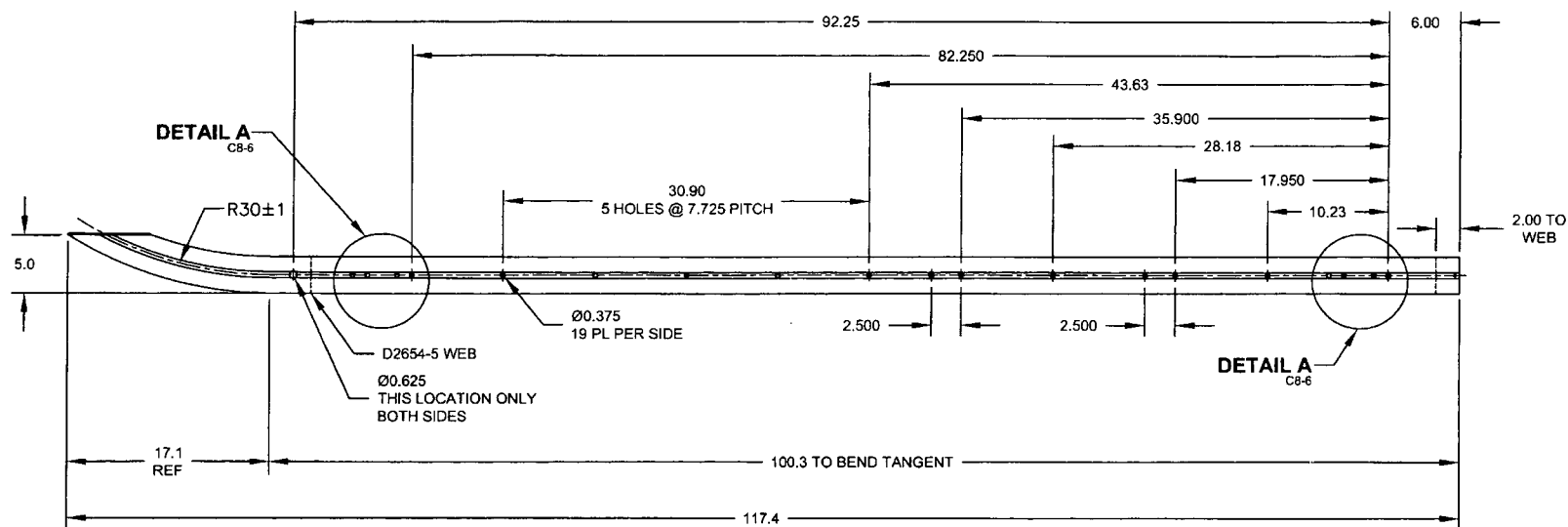
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

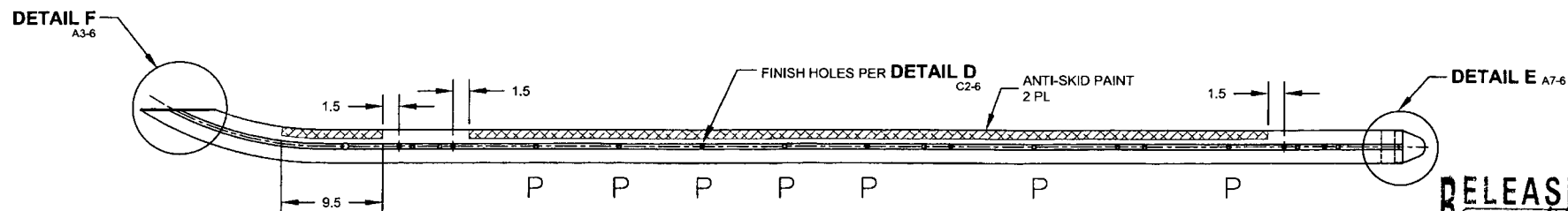
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

77709



D2650-5 BENDING/DRILLING DETAIL



D2650-5 ASSEMBLY/FINISHING DETAIL

RELEASED
08 09 27 11/17

DESIGN	DS	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED	J	DRAWING NO.	REV. F
MFG. APPR.	E	D2650	SHEET 4 OF 6
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

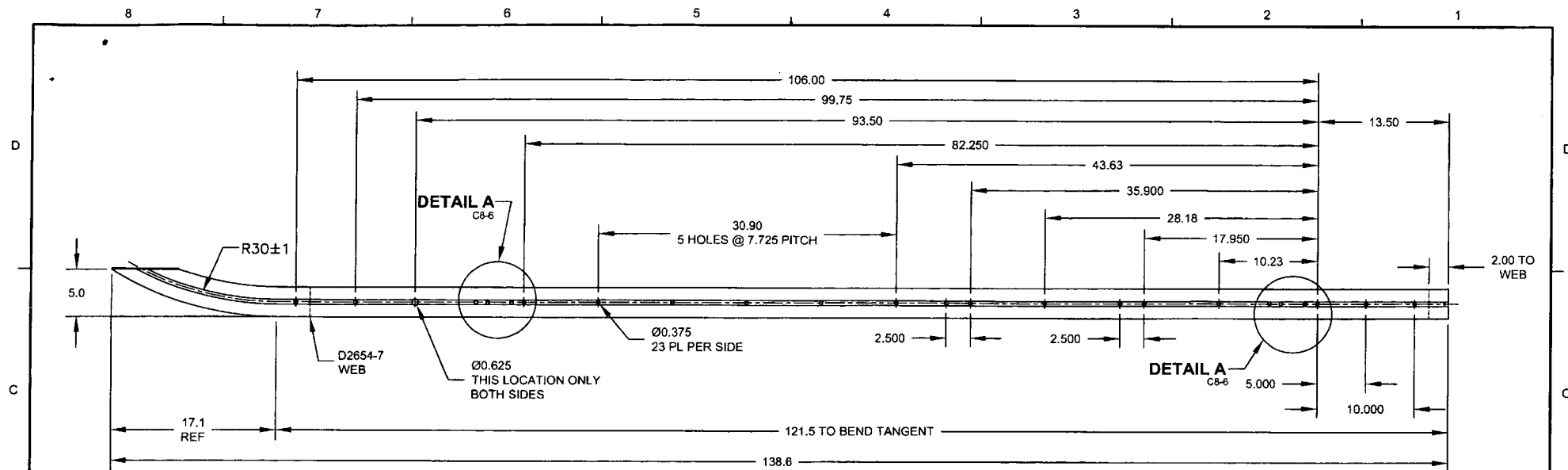
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

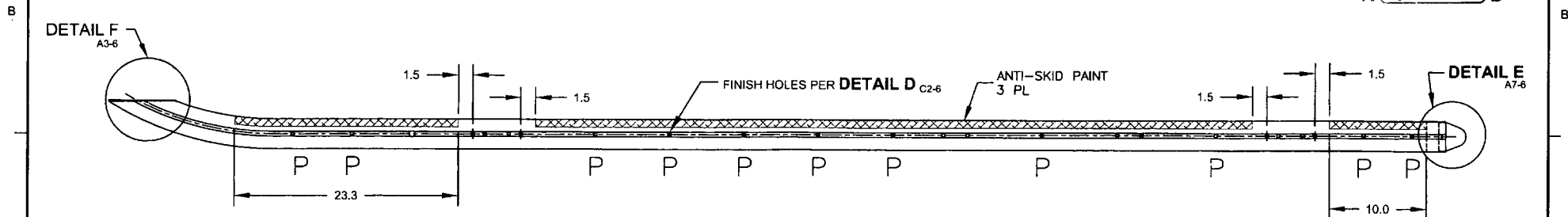
NOTE: Date & initial all entries

77709



D2650-7 BENDING/DRILL DETAIL

RELEASED
08 07 22 111



D2650-7 ASSEMBLY/FINISHING DETAIL

DESIGN	DS	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO. D2650	REV. F SHEET 5 OF 6
MFG. APPR.	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	206/407 SKIDTUBE ASSEMBLIES	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

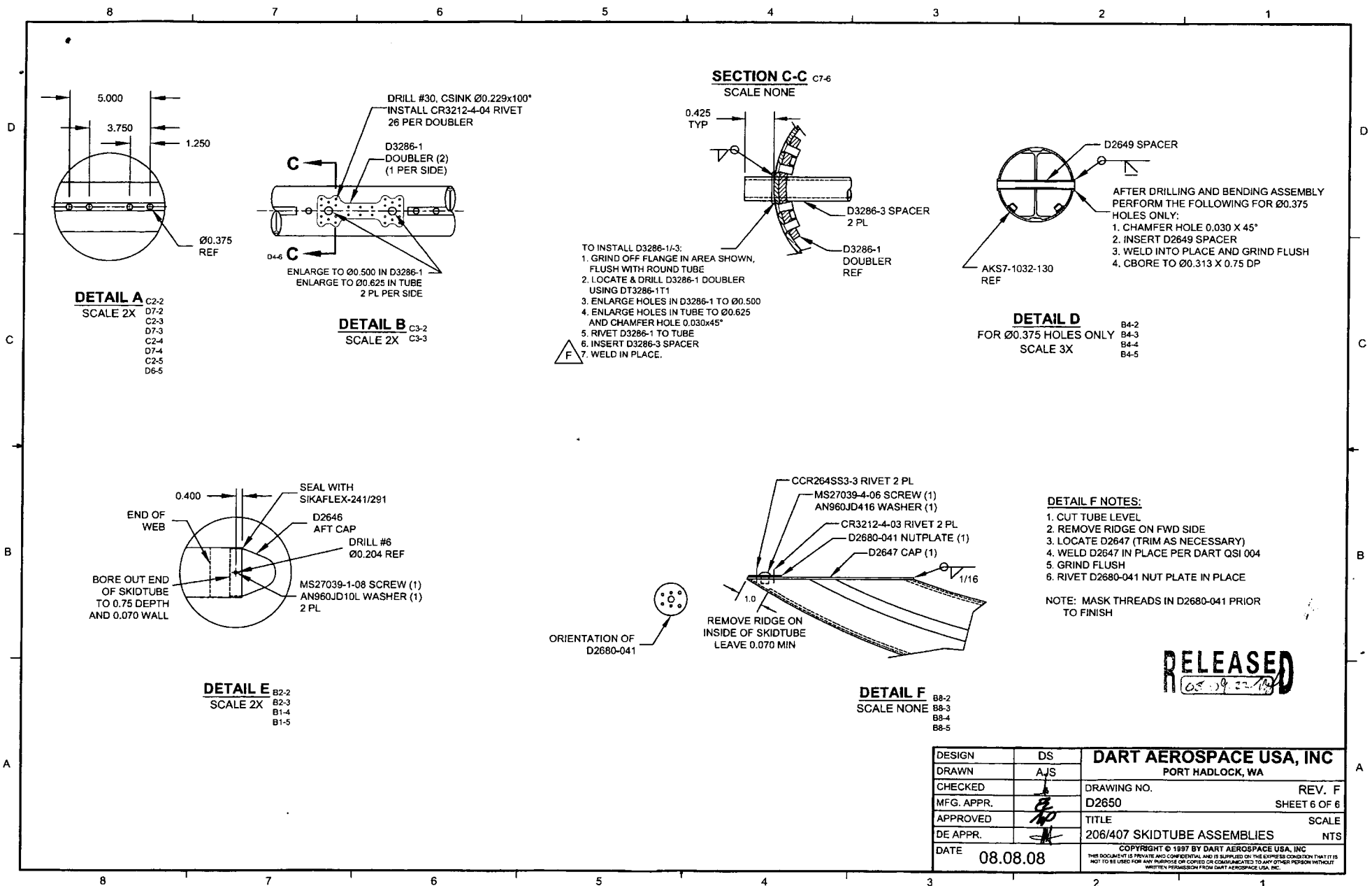
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____




Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

777 09



DESIGN	DS	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 6 OF 6
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action : Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

NO. 278

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliot
Job number: 766119
Part number: 206-642-151
Description: 206 skid tube
Welding Process: Tig ☒ Mig ☐
Base material: Aluminum
Current: AC ☒ DC ☐

TEST REQUIREMENTS AND RESULTS

Visual: pass ☒ fail ☐
Penetration: pass ☒ fail ☐

UNACCEPTABLE

Cracks: pass ☒ fail ☐
Undercut: pass ☒ fail ☐
Pin holes: pass ☒ fail ☐
Overlap (cold lap): pass ☒ fail ☐
Porosity (surface): pass ☒ fail ☐
Coloration: pass ☒ fail ☐

Qualifier Pat. Dunn Date of Test Coupon 11-12-20
Welder Barclay Elliot Date of Test Coupon 11-12-20

The above named individual is qualified in accordance with AWS D17.1.2001 to weld